

Date: Friday, 11/05/2007 1:11:30 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT ASSEMBLY
Job Number	: 32328	Part Number	: D3180041
Estimate Number	: 10808	Drawing Number	: D3180 REV A
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 11/05/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Revision	: A
First Issue	: N/A	Material	: N/A
Previous Run	: 24884	Due Date	: 18/05/2007
Written By	:	Qty:	2 Um: Each
Checked & Approved By	:		
Comment	: Est Rev.A 08.01.27 New issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0750W049	304 RD Tube .750 x .049W
		Comment: Qty.: 3.7625 f(s)/Unit Total : 7.5249 f(s) 304/316 Seamless Tubing with 3/4" O.D. x 0.049" wall (M304TR0.750W0.049) 0065 18 07-05-14 Batch: N104425
2.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE 1-Punch 304/316 Seamless Tubing with 3/4" O.D. x 0.049" wall to length as per Dwg D3180 using DT8313 Ensure rotate and punch one end only as per view B-B as per Dwg. D3180
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Drill Ø0.203" as per Dwg D3180 2-Bend one side only as per Dwg D3180 Identify as D3180-1 3-Deburr edges
4.0	QC5	INSPECT WORK TO CURRENT STEP
		 SB 07/05/14 (2)

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Seq. #:	Machine Or Operation:	Description :
5.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	
6.0	QOS	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	
7.0	D2022101	Spacer
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)	
	Pick:	
	Qty Part Number Description Batch	
	2 D2022-101 Spacer <u>B26664</u>	
8.0	D26906	Lanyard
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	Pick:	
	Qty Part Number Description Batch	
	1 D2690-6 Lanyard <u>B28579</u>	
9.0	A1449	Grommet
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)	
	Pick:	
	Qty Part Number Description Batch	
	1 D3180-1(ref) Strut <u>B32328</u>	
	1 A1449 Grommet <u>M1487</u>	
10.0	AN960JD10	Washer
	Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)	
	Pick:	
	Qty Part Number Description Batch	
	3 AN960JD10 Washer <u>M103947</u>	

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Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 BLRS001 Pip Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 BLRS-001 Pip Pin M15608

12.0 MS21042L3 Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS21042L3 Nut (or -3) M1C4215

13.0 MS27039110 Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-1-10 Screw M1883X

14.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3180

AB 07-05-14 ②

15.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/20-114 ②

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Job Number:



Seq. #: Machine Or Operation:

Description :

16.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *JB 07-05-14 ②*

17.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE *1707105/14*

Job Completion



✓ 07-05-14

DARTQA COPY
ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3180 REV. A
DATE		SHEET 1 OF 1

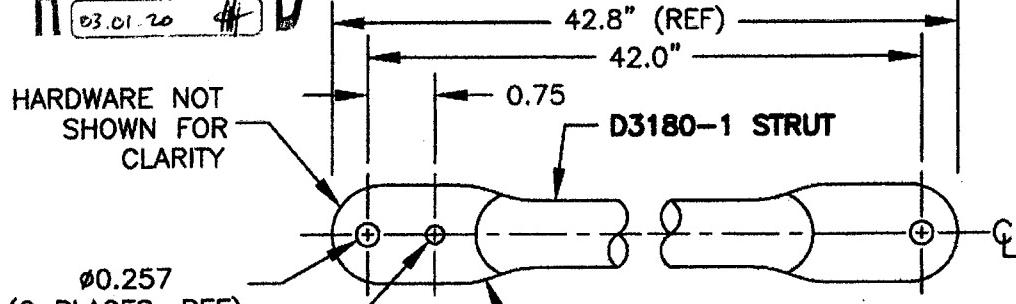
03.01.06 TITLE STRUT ASSEMBLY SCALE 1:1

RELEASED

03.01.06

A 03.01.06 NEW ISSUE

HARDWARE NOT SHOWN FOR CLARITY

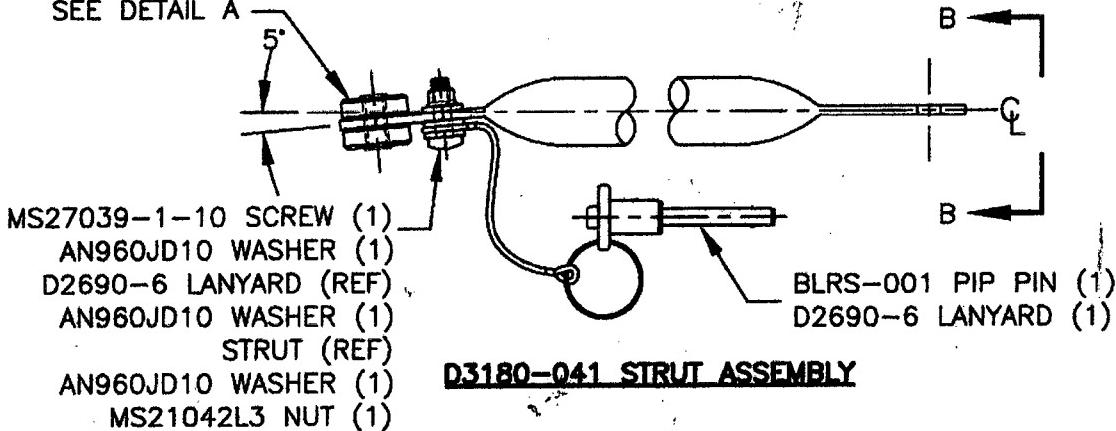
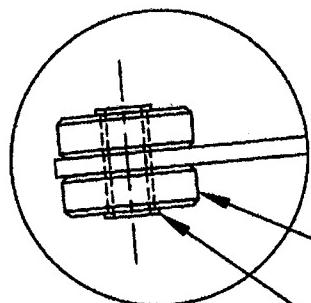


Ø0.257
(2 PLACES, REF)

Ø0.203

PUNCH BOTH ENDS PER SPEC
CONTROL DRAWING D2638

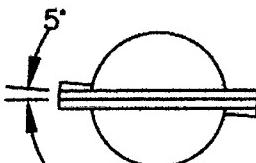
SEE DETAIL A

**D3180-041 STRUT ASSEMBLY**

DETAIL A
SCALE 1:1

D2022-101 SPACER
(2 PLACES)

SWAGE D2022-101 SPACERS ONTO
D3180-1 STRUT USING A1449 GROMMET
(1 PLACE)



VIEW B-B
SCALE 1:1

D3180-1 STRUT

- 1) MATERIAL: AISI 304/316/318 SS TUBE, Ø0.75 X 0.049 WALL
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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